



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G18331-3G
Job Sheet 172412



Part No: RBW6305G18331-3G

Job Qty: 3 ea

Part Name: Ecs Drill Quill Lip Seal Remover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G18331-3G Rev B IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		At 18/04/25
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		At 18/04/25
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		11 APR 25 2018
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3		9-00 APR 26 2018
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21		GA096

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 035084 MANUFACTURE RBW6305G18331-3G AS PER
Descriptions: DWG -Certificate of conformity is required

FEB 22 2018
21
9-00
APR 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G18331-3GP	Ecs Drill Quill Lip Seal Remover	3 (1 ea)	100-Purchasing	5065070

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G18331-3GP	3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

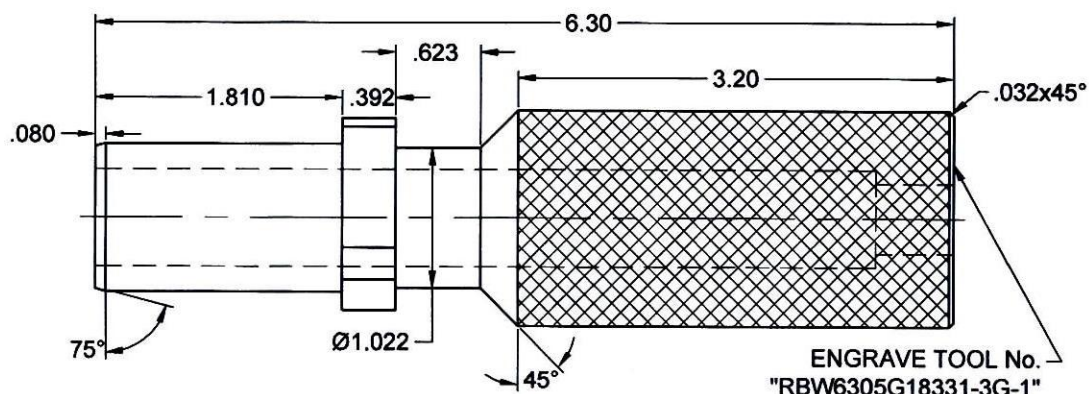
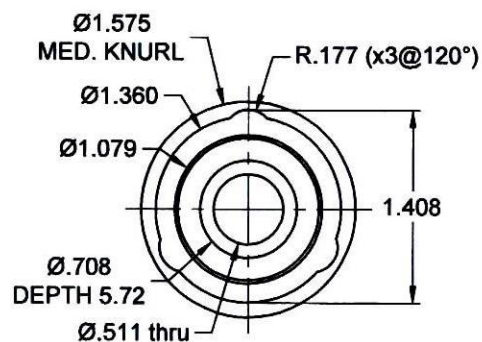
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐							
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																							
Description Work Order Deviation		Disposition																									
				Completed By																							
				Lead hand / Supervisor Approval Verification																							
				QC / QA Coordinator Approval																							
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">☐</td></tr> </table>	Environment ☐	☐	Design ☐	☐	Doc/Data ☐	☐	Equip/Tooling ☐	☐	Handling/Pre ☐	☐	Material ☐	☐	Internal Transport ☐	☐	Tribal Knowledge ☐	☐	LOA ☐	☐	Substation ☐	☐	Past Expiry Date ☐	☐	Misidentified ☐	☐	Dart Aerospace Ltd. 1270 Aberdeen Street Aberdeen, ON N6A 1K7 CANADA TEL: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S065081 Part: RBW6305G18331 - 3G Job No: 172412 Serial No/Batch: S065081 Revision: B Inspector: Date: 04/25/18 Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ io/Program ☐ in ☐ ld ☐ ing Stock Pulled ☐ of Sequence ☐ et ☐ ivislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	Marks/Chatter ☐ Manufacturing Process ☐ Past Due ☐	OTHER : _____
Environment ☐	☐																										
Design ☐	☐																										
Doc/Data ☐	☐																										
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Misidentified ☐	☐																										

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D -3 ENGRAVE NOTES PER R.W.	5/9/11	RJC	RW
B	CH'D TOOL NAME WAS ECS DRILL QUILL LIP SEAL REMOVER IS TOOL, ECS DRILL QUILL LIP SEAL REMOVER TO MATCH PARTS MANUAL.	11/4/13	RJC	RW



-1

HANDLE

NOTES

1. ALSO SOLD WITH KIT RBW6305G01531-3G, BOX TWO RBW6305G19731-3G.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	HANDLE	6061 RND. BAR	Ø1-5/8 x 6-1/2	1
			-3	1	RECEIVER	6061 RND. BAR	Ø6-1/4 x 2-3/8	2
ASSY #								

RED BARN MACHINE	
TITLE TOOL, ECS DRILL QUILL LIP SEAL REMOVER	
DWG NO. RBW6305G18331-3G	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	METRIC REF.
DECIMALS .XXX ± .005	.XXmm ± .1mm
XX ± .01	FRACTIONS ± 1/32
X ± .1	ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-4-11
SHEET 1 of 2	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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PURCHASE ORDER

PO039084

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				3G Rev. 1							
Line Item Note job# 172416											
15	RBW6305G14631-3GP			Tail Rotor Drive Quill Seal Housing Remover As Per Dwg RBW6305G14631-3G Rev. 1A	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,205.32/Ea	\$3,615.96
Line Item Note job# 172415											
16	RBW6305G14831-3GP			Tail Rotor Drive Quill Lip Seal Remover As Per Dwg RBW6305G14831-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$922.80/Ea	\$2,768.40
Line Item Note job# 172414											
17	RBW6305G16031-3GP			Drive Quill Seal Housing Remover As Per Dwg RBW6305G16031-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$981.65/Ea	\$2,944.95
Line Item Note job# 172413											
18	RBW6305G18331-3GP			Ecs Drill Quill Lip Seal Remover As Per Dwg RBW6305G18331-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$534.40/Ea	\$1,603.20
Line Item Note job# 172412											
19	RBW6305G18631-3GP			Ecs Drive Quill Housing Remover As Per Dwg RBW6305G18631-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,043.33/Ea	\$3,129.99
Line Item Note job# 172411											
20	RBW6305G19231-3GP			Puller Rotor Brake Adapter Flange Remover As Per Dwg RBW6305G19231-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$740.19/Ea	\$2,220.57
Line Item Note job# 172410											
21	RBW6305G19151-3GP			Guide Fan Drive Quill Seal Housing Installer As Per Dwg RBW6305G19151-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$132.32/Ea	\$396.96
Line Item Note job# 172402											
22	RBW6305G16231-3G-1P			Handle As Per Dwg RBW6305G16231-3G-1 Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$368.38/Ea	\$1,105.14



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 039084

Dated: 04/24/2018

Our Order / Job No: 14AWT

Order Qty: 3

Part Name: Tool, ESC Drill Quill Lip Seal Remover

Part Number: RBW6305G18331-3G

Lot Size: N/A

Ship Date: 04/24/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G18331-3G

Rev: B

Material Size and Type: -1/6061 ALUM.; -3/6061 ALUM.

Material Specifications: ALUM. – ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/24/18

Signed: Hernan M. Laht

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com